

JRAP *Rush*
122215

Work Order ID 122215

July-10-14 1:18:30 PM

Page 1

Item ID: D4970-3

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Windshield Deflector - Upper

Stop

NS2

Start Date: 7/10/14 Start Qty: 1.00

1
1

Cust Item ID:

Required Date: 7/10/14 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan: *MLJ*

Date: *14-07-16*

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4970

C

110

0.00

110

Outsource5

Memo

0.00

Outsource process - Machining

ISSUE P/O: *25010*
POSSIBLE SUPPLIER: WEJAY

Certificate of conformaty required

CL 14/07/15

115

Receive & Inspect for Damage & Mat'l Certs

0.00

115

Packaging

Memo

0.00

Packaging

5x SP 14-8-22

117

QC6- Inspect dimensions to drawing

0.00

117

QC

Memo

0.00

Quality Control

DAS
16
9-89

14/12/22

(X)

DAS
9-89
14-8-22

Work Order ID 122215

July-10-14 1:18:30 PM

122215

Page 2

Item ID: D4970-3 Accept *N900040100* Setup Start *NS1*

Revision ID: Stop *NS2*

Item Name: Windshield Deflector - Upper

Start Date: 7/10/14 Start Qty: 1.00 *1*

Required Date: 7/10/14 Req'd Qty: 1.00 *1*

Reference: Cust Item ID: Customer:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*

QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	Outsource process-Anodize per QSI017 4.1.10.1	0.00							
120									
Outsource4	Memo	0.00							
Outsource process - Anodize	Issue P/O to ATG : 25511								
	1- Black Anodize as per Dwg								
	Certification of Comformity is required								
130	Receive & Inspect for Damage & Mat'l Certs	0.00							
130									
Packaging	Memo	0.00							
Packaging									
140	QC5- Inspect part completeness to step on W/O	0.00							
140									
QC	Memo	0.00							
Quality Control									

CX 14/08/25 5

P14/08/27 (5)

5 DAS 38 9-89 14-8-27

Work Order ID 122215

July-10-14 1:18:30 PM

122215

Page 3

Item ID: D4970-3

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Windshield Deflector - Upper

Start Date: 7/10/14

Start Qty: 1.00

1

Cust Item ID:

Required Date: 7/10/14

Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

Identify as per dwg & Stock Location: MF

0.00

180

Packaging

Memo

0.00

Packaging

IDENTIFY BY STAMPING P# AND REV

① SMO 14/08/27

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

MLJ 14-08-27

MLJ 14-08-27

Picklist Print

July-10-14 1:18:33 PM

Page 1

Work Order ID: 122215

122215

Parent Item: D4970-3

D4970-3

Parent Item Name: Windshield Deflector - Upper

Start Date: 7/10/14

Required Date: 7/10/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A NEW ISSUE JLM 13-11-17 VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M7075T6B4.000X03.00 0		Purchased		No			f	6.0600		3			

M7075T6B4 000X03 000

7075-T6 BAR 4.000' X 3.000"

Location

Loc Qty

Loc Code

MAT001

6.06

125584

1

M127736

5.06

mat supplied by
Wegley

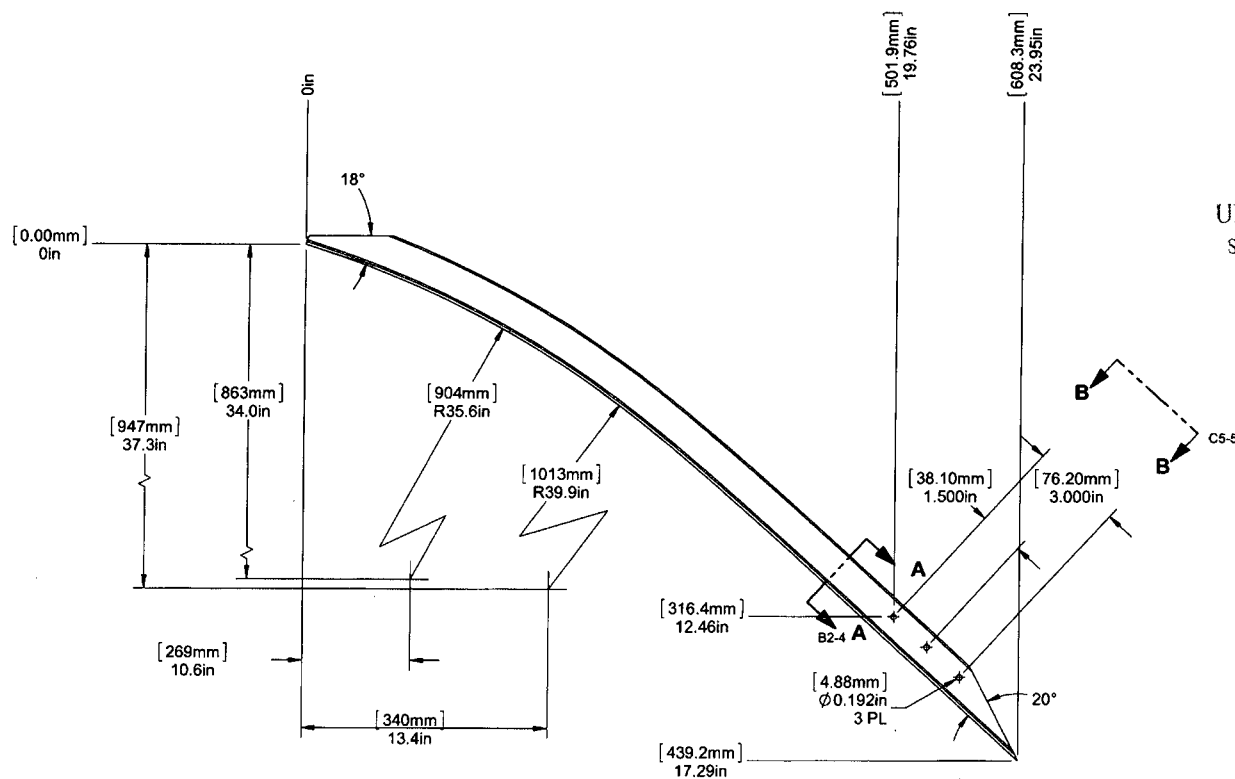
D4970-3 P

X5

122215

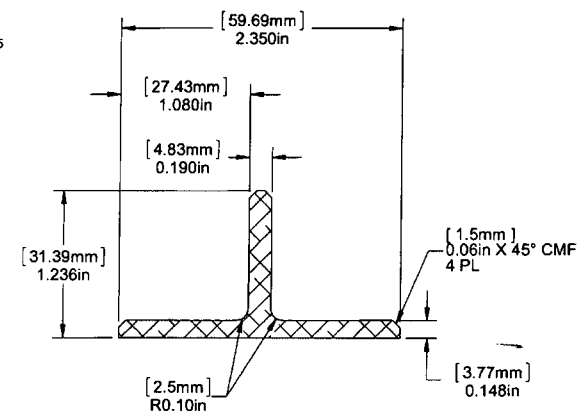
MF

14-8-27



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 122215 MLC
14-07-10



SECTION A-A
BS-4

D4970-3 WINDSHIELD DEFLECTOR - UPPER

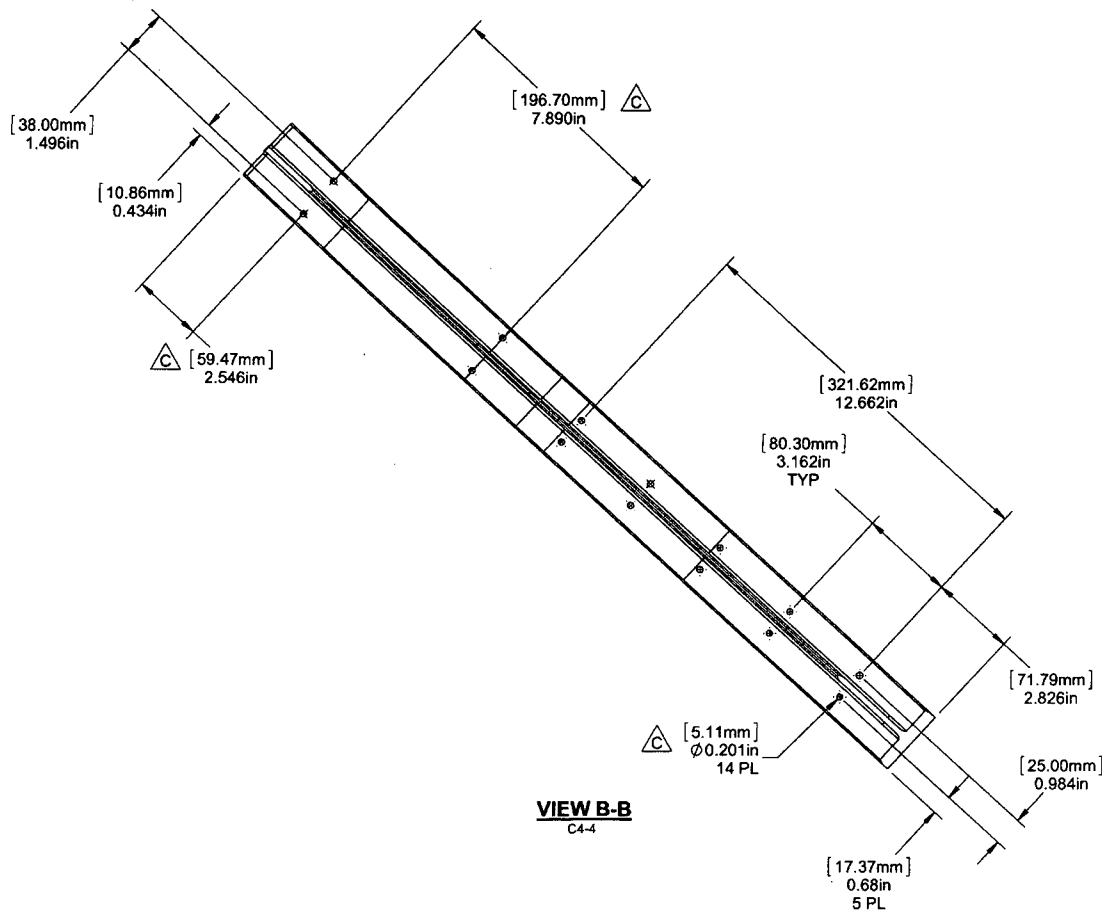
NOTES:

- 1) MATERIAL: 7075-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR
PER AMS-QQ-A-225/9 (OR AMS 4122/4123/4186/4187) OR
PER AMS-QQ-A-200/11 (REF DART SPEC M7075T6B)
- 2) FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4970-3", REVISION, BATCH NUMBER AND
DATE OF MANUFACTURE, USING AN X-TENSION STAMP, PER QSI 044 METHOD 6.2
- 7) WEIGHT: 1.60 lbs (0.73 kgs)
- 8) PART DIMENSIONS CONTROLLED BY CAD MODEL FILE: D4970-3-c.IGES

APPROVED

DESIGN	DC	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	HS	DRAWING NO.	REV. C
MFG. APPR.	JLM	D4970	SHEET 4 OF 6
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	WINDSHIELD DEFLECTOR	NTS
DATE	14.06.05	COPYRIGHT © 2013 BY DART AEROSPACE LTD	
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RELEASED
2014-06-11



D4970-3 WINDSHIELD DEFLECTOR - UPPER

RELEASED
2014-06-11
MD

APPROVED	DESIGN	DC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
	DRAWN	RF		
	CHECKED	HS	DRAWING NO.	REV. C
	MFG. APPR.	JLM	D4970	SHEET 5 OF 6
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	WINDSHIELD DEFLECTOR	NTS
	DATE	14.06.05	<small>COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO25010**

Purchase Order Date 7/15/2014

PO Print Date 7/15/2014

Page Number 1 of 2

Order From :

VC-WMP001

WEJAY MACHINE PRODUCTS CO. LTD
600 O'CONNOR DRIVE
KINGSTON, ONTARIO K7P 1N3
CANADA

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FAXED

Contact Name

Vendor Phone 613-384-1662

Ship To Contact

Ship To Phone

Ship Via: FedEx PI ppd

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

COD

Currency

CAD

FOB

Destination-Collect

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extend Pri
----------	---	------------------------	--------------------------------------	----	--------------------------------	---------------	---------------

1	D4970-3P AS PER DWG D4970 REV. C B122215	Windshield Deflector, Upper	8/22/2014 Yes 8/22/2014	FN	5.00 Each	\$950.00	\$4,750.00
---	--	--------------------------------	-----------------------------------	----	------------------	----------	------------

Line Total: \$4,750.00

2	D4977-1P AS PER DWG D4977 REV. C B122387	Bracket, LH	8/22/2014 Yes 8/22/2014	FN	5.00 Each	\$425.00	\$2,125.00
---	--	-------------	-----------------------------------	----	------------------	----------	------------

Line Total: \$2,125.00

Note:

7/15/2014



Packing Slip 36927

600 O'CONNOR DRIVE, KINGSTON, ONTARIO K7P 1
TEL: 613-384-1662 FAX: 613-384-21
www.wejay.c

S
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L
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T
O
Dart Aerospace
1270 Aberdeen Street
Hawkesbury ON K6A 1K7

S
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O
Dart Aerospace
1270 Aberdeen Street
Hawkesbury ON K6A 1K

INVOICE DATE		YOUR ORDER NO. PO25010		DATE ORDERED 07/15/14		SHIPPED VIA Best way	
CUSTOMER CODE DART			PROV. LIC. NO.		Extra <input type="checkbox"/> Exempt <input type="checkbox"/>		TERMS
QUANTITY ORDERED	B.O.	QUANTITY SHIPPED	DESCRIPTION			UNIT PRICE	AMOUNT
5	-	5	Windshield deflector, upper as per drawing D4970, Rev. C D4970-2P B122215				
5	-	5	Bracket, left hand as per drawing D4977-1, Rev. C D4977-1P B122387				
5	-	5	Bracket, right hand as per drawing 4977-2, Rev. C D4977-2P B122388				
Required by: August 22, 2014							
<p align="center">RELEASE NOTE</p> <p>I certify that the items listed hereon have been inspected and tested and conform to all specifications and requirements in the contract or purchase order.</p> <p>Inspection Supervisor <u>[Signature]</u> WMP 03</p> <p align="center">11 Aug. 21/14</p>							
						G.S.T.	
						P.S.T.	

ORDER: COMPLETE ☐
PARTIAL ☐

TOTAL

RECEIVED BY _____
1.5% PER MONTH (18% PER ANNUM)
CHARGED ON OVERDUE ACCOUNTS

NO GOODS RETURNED WITH
PRIOR AUTHORIZATION



600 O'CONNOR DRIVE, KINGSTON, ONTARIO K7P 1N3

PHONE: (613) 384-1662

FAX: (613) 384-2991

CERTIFICATE OF COMPLIANCE

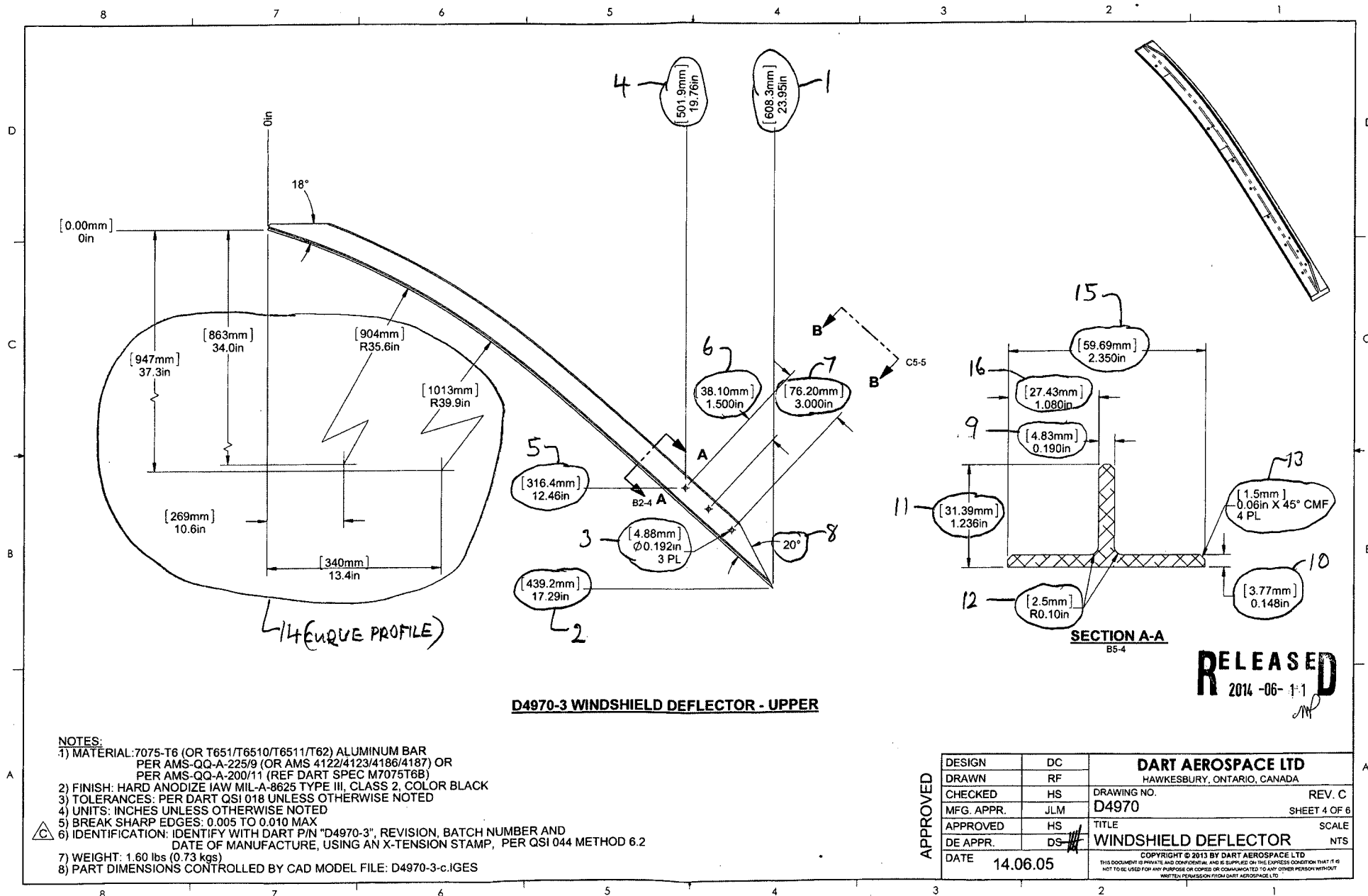
CUSTOMER: Dart Aerospace Ltd.		DATE: Aug. 21, 2014	
		P.O.# PO25010	
		WEJAY JOB# 36927	
<p>I hereby certify that the following material has been inspected/tested and conforms to the requirements and specifications as stated in your contract and as noted below. Any exceptions will be listed as NCR items.</p>			
PART NO.	QTY.	PROCESS (ES)	SPECIFICATION / REV
D4970-3P 'Upper Windshield Deflector' B122215	5	Machined complete per drawing req'ts.	D4970 / rev. C
D4977-1P 'Bracket, Left Hand' B122387	5	Machined complete per drawing req'ts.	D4977 / rev. C
D4977-2P 'Bracket, Right Hand' B122388	5	Machined complete per drawing req'ts.	D4977 / rev. C
Note: 1) Material is Dart Aerospace free issue. Ref. Dart PO# PO22281. 2) 1st Article Inspection reports attached.			

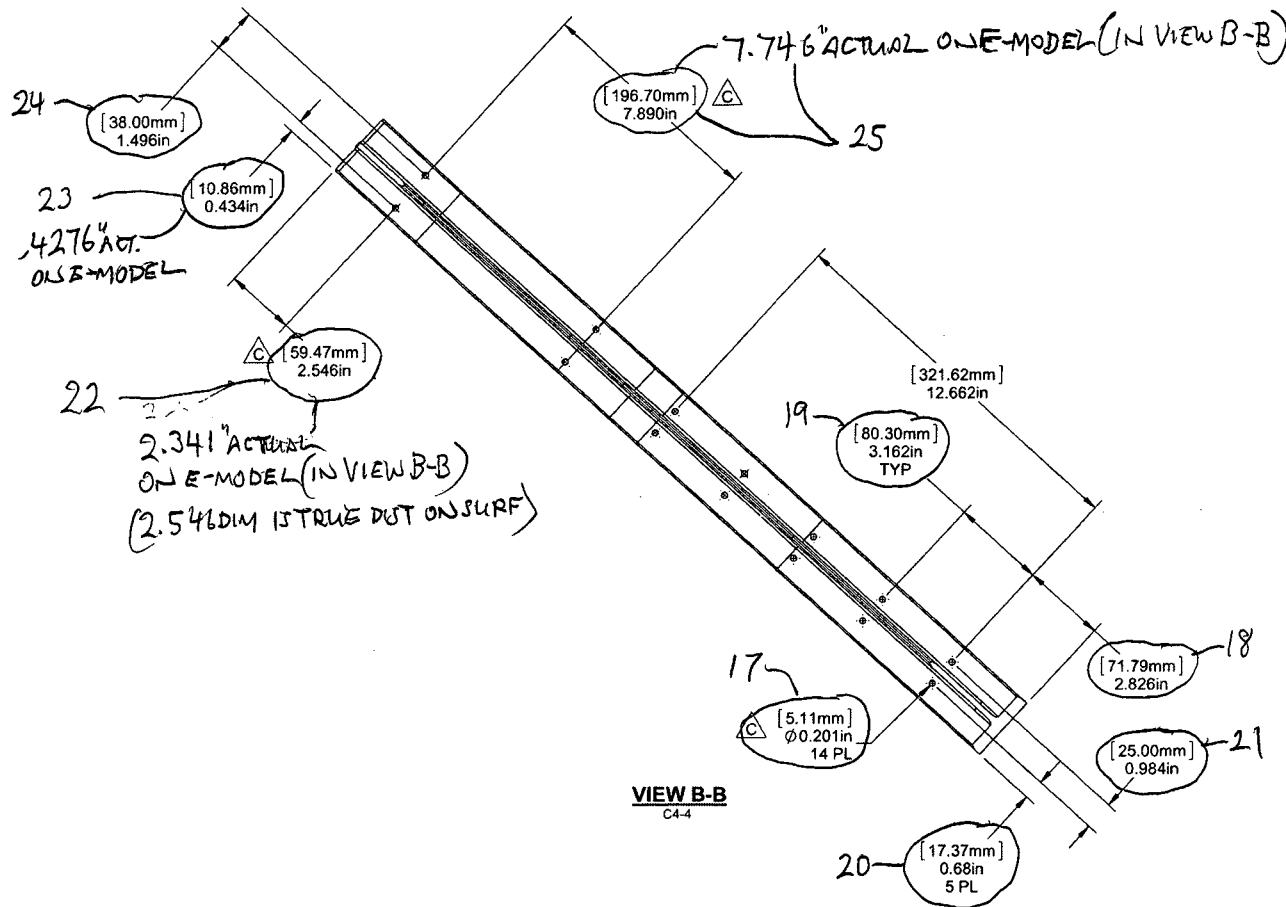
Records of Inspection/Test will be retained for 5 years minimum.

Yours truly,

Clifford Smith
Authorized Q.A. Signatory

H 36927





D4970-3 WINDSHIELD DEFLECTOR - UPPER

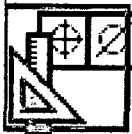
RELEASED
2014-06-11

APPROVED	DESIGN	DC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
	DRAWN	RF		
	CHECKED	HS	DRAWING NO. D4970	REV. C
	MFG. APPR.	JLM	SHEET 5 OF 6	
	APPROVED	HS	TITLE WINDSHIELD DEFLECTOR	SCALE NTS
	DE APPR.	DS	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
	DATE	14.06.05		



Customer Dart Aerospace Ltd. Customer P.O. PO25010
 Drawing # D4970 Drawing rev C
 Part Number D4970-3 E.C.O. --
 Part Name Windshield Deflector - Upper Material Aluminum Alloy 7075-T651
 Serial # 001 Inspected by Cliff Smith
 Job # 36927 Signature:


WMP
03
ACCEPTED
Aug 21/14

**Overall Result**

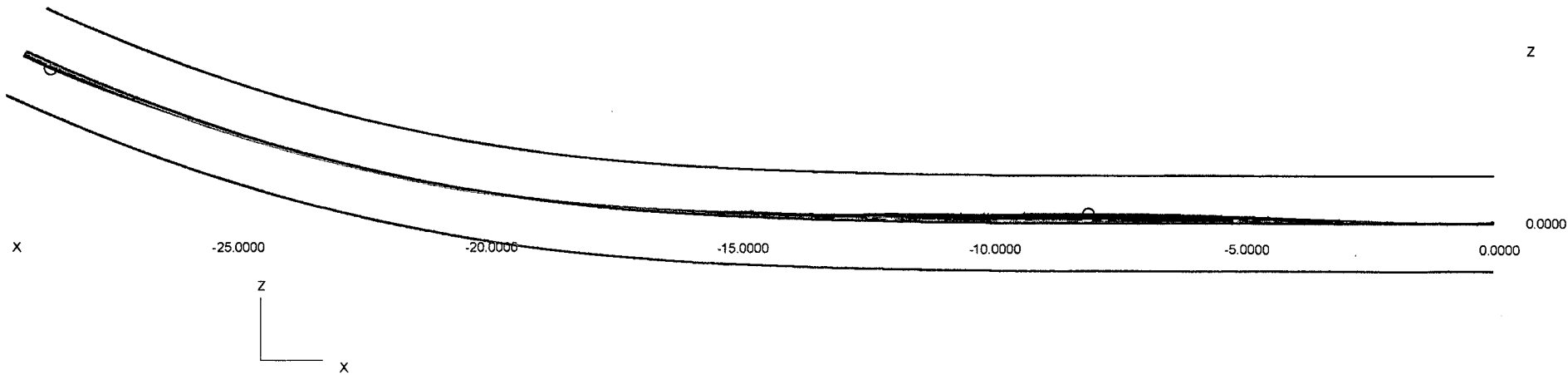
All Characteristics: 71
 Out of tolerance: 0
 Over Warning Limit: 0
 Not Calculated: 0

Comment: 1) Material supplied by DAS
 7075-T651 per ASTM B209-10
 ref. Lot# 718252, ref. PO22281

Feature	ID	Actual	Nominal	Pos Tol.	Neg Tol.	Deviation	<-- -->
<input type="checkbox"/> 1 4_D4	X	23.9441	23.9500	0.0300	-0.0300	-0.0059	-
<input type="checkbox"/> 2 4_B5	Z	-17.3120	-17.2900	0.0300	-0.0300	-0.0220	---
<input type="checkbox"/> 3a 4_B5	D	0.1912	0.1920	0.0050	-0.0010	-0.0008	---
<input type="checkbox"/> 3b 4_B5	D	0.1911	0.1920	0.0050	-0.0010	-0.0009	---
<input type="checkbox"/> 3c 4_B5	D	0.1911	0.1920	0.0050	-0.0010	-0.0009	---
<input type="checkbox"/> 4 4_D5	X	19.7479	19.7600	0.0300	-0.0300	-0.0121	-
<input type="checkbox"/> 5 4_B5	Z	-12.4743	-12.4600	0.0300	-0.0300	-0.0143	-
<input type="checkbox"/> 6 4_C4_3d	Dist	1.5002	1.5000	0.0100	-0.0100	0.0002	-
<input type="checkbox"/> 7 4_C4_3d	Dist	2.9999	3.0000	0.0100	-0.0100	-0.0001	-
<input type="checkbox"/> 8 4_B4	A	20.1473	20.0000	0.5000	-0.5000	0.1473	-
<input type="checkbox"/> 14 4_B6_Flange Curve Profile	CurveForm	0.0089	0.0000	0.0300	-0.0300	0.0089	-
<input type="checkbox"/> 15a 4_C2	3d Dist	2.3497	2.3500	0.0100	-0.0100	-0.0003	-
<input type="checkbox"/> 15b 4_C2	3d Dist	2.3501	2.3500	0.0100	-0.0100	0.0001	-
<input type="checkbox"/> 15c 4_C2	3d Dist	2.3504	2.3500	0.0100	-0.0100	0.0004	-
<input type="checkbox"/> 15d 4_C2	3d Dist	2.3509	2.3500	0.0100	-0.0100	0.0009	-
<input type="checkbox"/> 15e 4_C2	3d Dist	2.3509	2.3500	0.0100	-0.0100	0.0009	-
<input type="checkbox"/> 15f 4_C2	3d Dist	2.3503	2.3500	0.0100	-0.0100	0.0003	-
<input type="checkbox"/> 15g 4_C2	3d Dist	2.3504	2.3500	0.0100	-0.0100	0.0004	-
<input type="checkbox"/> 16a 4_C2_Y	Dist	1.0811	1.0800	0.0100	-0.0100	0.0011	-
<input type="checkbox"/> 16b 4_C2_Y	Dist	1.0810	1.0800	0.0100	-0.0100	0.0010	-
<input type="checkbox"/> 16c 4_C2_Y	Dist	1.0806	1.0800	0.0100	-0.0100	0.0006	-
<input type="checkbox"/> 16d 4_C2_Y	Dist	1.0797	1.0800	0.0100	-0.0100	-0.0003	-
<input type="checkbox"/> 16e 4_C2_Y	Dist	1.0786	1.0800	0.0100	-0.0100	-0.0014	-
<input type="checkbox"/> 16f 4_C2_Y	Dist	1.0775	1.0800	0.0100	-0.0100	-0.0025	---
<input type="checkbox"/> 16g 4_C2_Y	Dist	1.0781	1.0800	0.0100	-0.0100	-0.0019	-
<input type="checkbox"/> 17a 5_B4(1)	D	0.2012	0.2010	0.0100	-0.0100	0.0002	-
<input type="checkbox"/> 17a 5_B4(2)	D	0.2013	0.2010	0.0100	-0.0100	0.0003	-
<input type="checkbox"/> 17a 5_B4(3)	D	0.2014	0.2010	0.0100	-0.0100	0.0004	-
<input type="checkbox"/> 17a 5_B4(4)	D	0.2013	0.2010	0.0100	-0.0100	0.0003	-
<input type="checkbox"/> 17a 5_B4(5)	D	0.2012	0.2010	0.0100	-0.0100	0.0002	-
<input type="checkbox"/> 17a 5_B4(6)	D	0.2014	0.2010	0.0100	-0.0100	0.0004	-
<input type="checkbox"/> 17a 5_B5(1)	D	0.2014	0.2010	0.0100	-0.0100	0.0004	-

	Calypso 5.2.18.01	Carl Zeiss	Date Order	August 18, 2014
Part Number	CMM Type CONT_G2	Drawing No.	Department:	
			Operator	Master
Meas. Plan Name	D4970 rev.C		Signature:	

1: 14 4_B6_Flange Curve Profile



No	Identifier	Sigma [in]	Form [in]	Number of Points	Lower Tol. [in]	Upper Tol. [in]	MinInd	Min Dev. [in]	MaxInd	Max Dev. [in]	Best Fit	X [in]	Y [in]	Z [in]	Rotation	X •	Y
1	14 4_B6_Flange Curve Profile	0.0030	0.0089	9970	-0.0300	0.0300	9776	-0.0032	2713	0.0057	Translation	0.0000	0.0000	0.0000	Rotation	0.0000	0.0000



A.T.G. Industries Inc.
731, rue Industrielle Rd.
PLATING DEPARTMENT
Rockland, On K4K 1T2
Canada
Ph: (613) 446-4544
Fax: (613) 446-4556

Pack List

Number: 63226

Date: 27-Aug-14

To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ship To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ph: 613-632-5200

Fax: 613-632-1185

Ph: 613-632-5200

Fax: 613-632-1185

Terms		Ship Via	
Quantity	Description	Rev:	Line:
5 ea	Part: D4977-1 HARD ANODIZE AS PER MIL-A-8625 TY III, CLASS 2 Job: 20140538 PO: PO25511		
5 ea	Part: D4977-2 HARD ANODIZE AS PER MIL-A-8625 TY III, CLASS 2 Job: 20140539 PO: PO25511		
5 ea	Part: D4970-3 HARD ANODIZE AS PER MIL-A-8625 TY III, CLASS 2 Job: 20140540 PO: PO25511		
<p align="center">Certificate of Conformance</p> <p>A.T.G. Industries certifies that all items in this shipment are in conformance with all requirements, specifications and drawings referenced in the purchase order.</p> <p align="center">ISO 9001 : 2008 REGISTERED ATG SALES-2010 TERMS APPLY</p> <p>DATE: <u>27/8</u></p> <p>CERTIFIED SIGNATURE: </p> <p>RECEIVER SIGNATURE: </p>			